

1st test 28/02

Dart Aerospace Ltd.

Split

Date: Friday, 09/01/2009 11:03:23 AM  
 User: Julie Dawson

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BIPOD MOUNT ASS'Y  
 Job Number : 44525 - 1  
 Estimate Number : 13184  
 P.O. Number :  
 This Issue : 09/01/2009 S.O. No. :  
 Prsht Rev. : NC Part Number : D3685041  
 First Issue : / / Type : MACHINED PARTS Drawing Number : D3685 REV B  
 Previous Run : 38479 Drawing Revision : B  
 Material :  
 Due Date : 26/01/2009 Qty: 3 Um: Each  
 Written By :  
 Checked & Approved By : DD 09.01.09  
 Comment : Est Rev:A new issue 08-02-12 DD verified by:LL  
 Est Rev:B As per Rev B 09-01-07 JLM Verified By:EC

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

2.0	D36873	MOUNT
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)  
 MOUNT  
 batch B44684

EB 09/04/16

3.0	D3684047	FWD LEG ASS'Y
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)  
 FWD LEG ASS'Y  
 batch B44681

9/4/27

SV

4.0	D3684049	AFT LEG ASS'Y
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)  
 AFT LEG ASS'Y  
 batch B44682

9/4/27

SV

5.0	D36921	SPACER
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)  
 SPACER  
 batch B46053

EB 09/04/16

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 09/01/2009 11:03:23 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BIPOD MOUNT ASSY

Job Number: 44525

Part Number: D3685041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

AN3C12A

Bolts



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Bolts

batch

M110155 (84)

M1101552 (82)

Ep09/04/16

7.0

MS210433

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Nut

batch

M111041

Ep09/04/16

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: 1-Use anti-seize compound on thread and assemble as per dwg D3684

FF 09-04-30

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 02/05/04 (x3)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location:

139C

9/5/4

SP

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/04

Job Completion



MF 09-05-04



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

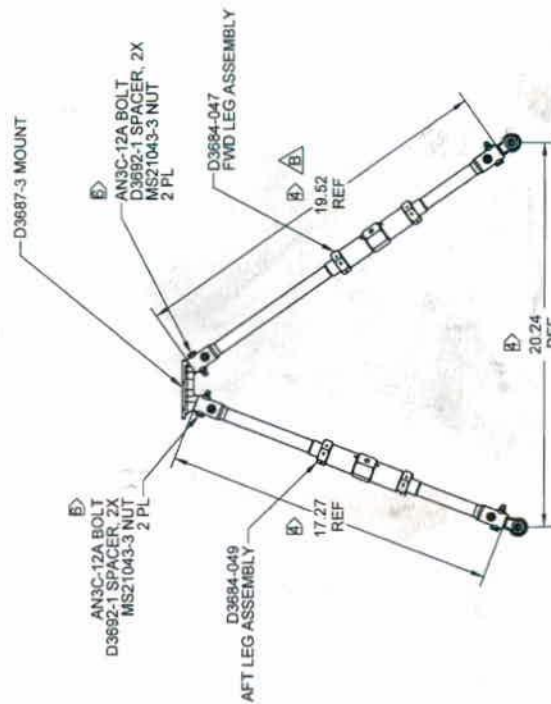
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

ITEM	QTY	PART NUMBER	DESCRIPTION
1	X	D3685-041	BIPOD MOUNT ASSEMBLY
2	1	D3687-3	MOUNT
3	1	D3684-047	FWD LEG ASSEMBLY
4	1	D3684-049	AFT LEG ASSEMBLY
5	8	D3692-1	SPACER
6	4	AN3C-12A	BOLT
7	4	MS21043-3	NUT



**D3685-041 BIPOD MOUNT ASSEMBLY**

- NOTES:
- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 2) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 3) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3685-041 USING FINE POINT PERMANENT INK MARKER
  - 4) DIMENSIONS SHOWN ARE WHEN D3688-1/3 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVES
  - 5) WEIGHT: 6.6 lbs
  - 6) TORQUE FASTENERS TO 20-25 in-lbs

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO 44525

RELEASED  
08/12/15-JUP

B		19.52 WAS 19.55 (2N B4-1); REFORMATTED TO CURRENT DWS STANDARDS		RF	08.11.24
A		NEW ISSUE		RF	08.05.22
REV.	DESCRIPTION	BY	DATE		
DESIGN	RF	DART AEROSPACE LTD			
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA			
CHECKED	RF	DRAWING NO.			
MFG. APPR.	RF	D3685			
APPROVED	RF	TITLE			
DE APPR.	RF	BIPOD MOUNT ASSEMBLY			
DATE	08.11.24	SCALE			
		SHEET 1 OF 1			
		NTS			
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